

Date: Friday, 11/16/2007 7:21:20 AM
 By: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: RADIUS BLOCK	
Job Number	: 35812		Part Number	: D36011	
Estimate Number	: 12813		Drawing Number	: D3601 REV A	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 11/16/2007 S.O. No. : N/A		Drawing Revision	: A	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 11/30/2007	
Previous Run	: 31634		Qty:	80	
Written By	: J.L. 07/11/06		Um:	Each	
Checked & Approved By					
Comment	: Est Rev A New Issue 07-03-28 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0750X00125	6061-T6 Bar .75" x .125" 
Comment: Qty.: 0.0962 f(s)/Unit Total : 3.8472 f(s) 6061-T6 Bar .75" x .125" Material: 6061-T6 (QQ-A-250/11) or 5052-H34 (QQ-A-250/8) 1/8" X 3/4" BarBatch <u>M104725</u> J.L 07/11/19		
2.0	SHEAR	SHEAR 
Comment: SHEAR Shear blanks 9.00" long +/- 0.030" Note: 1 blank makes 8 pieces <u>J.L 07/11/19</u>		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 
Comment: HAAS CNC VERTICAL MACHINING #1 1- Mill as per Folio FA682 Rev: <u>A</u> & Dwg D3601 Rev: <u>A</u> <u>SD 07.12.11</u> <u>119</u>		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>SD 07.12.11</u> <u>119</u>		
5.0	QC8	SECOND CHECK 
Comment: SECOND CHECK <u>J.L 07/12/14</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 08/01/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/16/2007 7:21:20 AM
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Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble

SMS

08/01/11

119 counted

Deburr any rough edges after tumbling

08/01/09 119

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



119

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BK

08-01-16

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



08-01-18

18

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST114

AS 08/01/17

x119

119

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/01/18

Job Completion



08-01-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

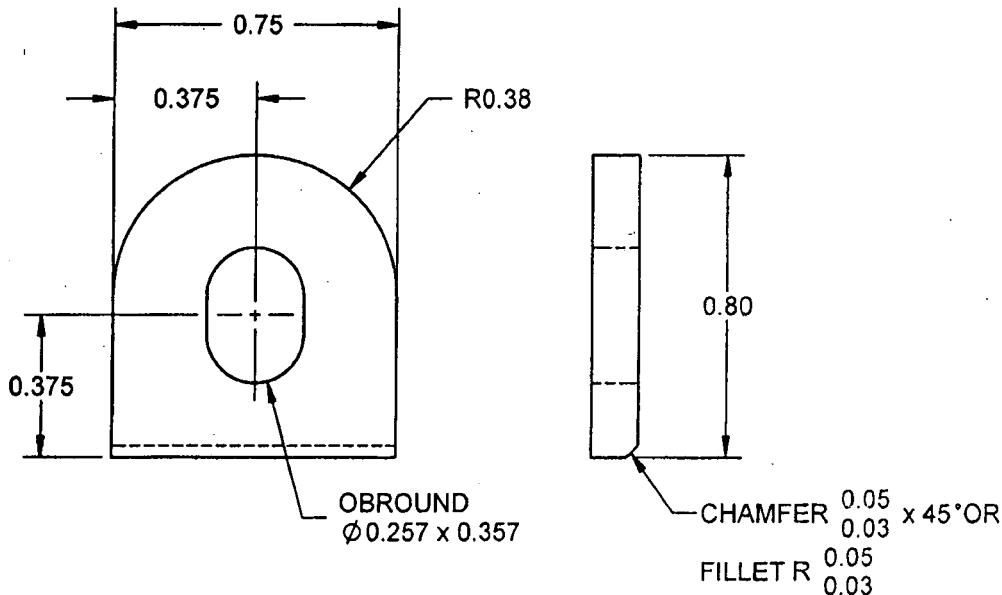
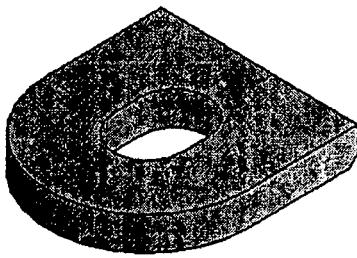
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>JB</i>	APPROVED <i>JB</i>	DRAWING NO. D3601	REV. A	SHEET 1 OF 1
DATE 07.02.13		TITLE RADIUS BLOCK	SCALE	2:1
REV A	DATE 07.02.13	DESCRIPTION NEW ISSUE		

RELEASED

07.03.08 *#***D3601-1 RADIUS BLOCK****NOTES:**

- 1) MATERIAL: ALUMINUM 5052-H32 SHEET, 0.125 THICK PER QQ-A-250/8 OR AMS 4016 **SHOP COPY**
(REF DART SPEC M5052H32S.125) OR
ALUMINUM 6061-T6 SHEET, 0.125 THICK PER QQ-A-250/11 OR AMS 4025/4027 **RETURN TO ENGINEERING**
(REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 **UNCONTROLLED COPY**
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3601-1" USING FINE POINT PERMANENT INK MARKER **SUBJECT TO AMENDMENT**
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.050 MAX **WITHOUT NOTICE**

*WORK ORDER
NO. 35812*

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DART AEROSPACE LTD		Work Order:	
Description:		Part Number:	
Inspection Dwg:	Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:		Audited by:		Prototype Approval:	
Date:	07-12-11	Date:	02/12/11		Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	